

Work Order ID 127246

127246

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Monday, December 15, 2014 2:33:38 PM

Item ID: D4753-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Doubler
 Start Date: 12/15/2014 Start Qty: 100.00 *100* Cust Item ID:
 Required Date: 12/15/2014 Req'd Qty: 100.00 *100* Customer:
 Reference:

Approvals: Process Plan: MCS Date: 14-12-15 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4753	A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D4753 Dwg Rev: <u>A</u> Prog Rev: <u>A</u>								
	***.758" DIA HOLE TO BE OPENED TO FIN SIZE BY SKID DEPARTMENT UPON INSTALLATION**								
	3- Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

(100)

DC 14/12/23

(100)

DC 14/12/23

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Reference:

Stop *NR2*

150

150

Small Fab

Small Fab

Small Fab

Memo

C'sink as per Dwg D4753
(On Flat side)

0.00

0.00

160

160

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

170

170

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

100x

15/01/08 DAS 36 9-8

100

DAS
38
9-89

JAN 08 2015

166

15-1-14 Doc JL

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC7-Inspect Chemical Conversion Coat	0.00							DAS 38 9-89
180									
QC	Memo	0.00							
Quality Control									JAN 15 2015
190	Identify as per dwg & Stock Location: <u>L6002</u>	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

(100)

15-1-15
(100)

MLJ 15-01-15

(H) 15-1-15

Picklist Print

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Work Order ID: 127246

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Parent Item: D4753-1

D4753-1

Parent Item Name: Doubler

Start Date: 12/15/2014

Required Date: 12/15/2014

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP REV:A NEW ISSUE 13-02-21 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.125

Purchased

No

sf

41.2500

2

M6061T6S 125

Dec 14/12/23

6061-T6 .125 Sheet

Location

Loc Qty

Loc Code

MAT020

41.25

m127454

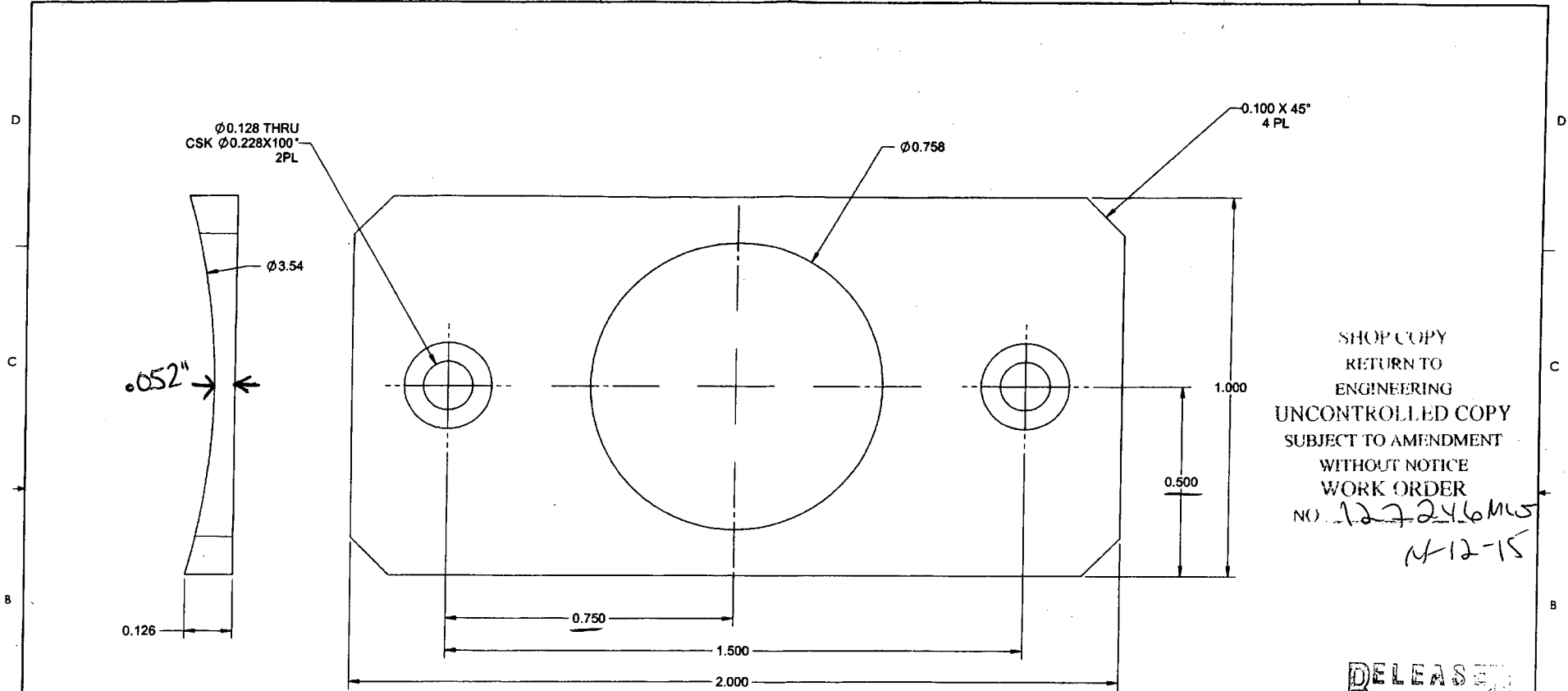
2.25

m130745

39

20399

8 7 6 5 4 3 2 1



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 127246MLS
4-12-15

RELEASED
2013-03-25
WD

NOTES:

- 1) MATERIAL: 6061-T6/T651 ALUMINUM PER QQ-A-250/11
REF DART SPEC M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4753-1" AND B/N PER QSI 044 METHOD 6.7
- 7) WEIGHT: 0.01 lbs

A NEW ISSUE		AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	AP	D4753	SHEET 1 OF 1
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	DOUBLER	NTS
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8 7 6 5 4 3 2 1

